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EUROPE MIDDLE EAST AFRICA

RESEARCH AND DEVELOPMENT

Monthly Progress Reports

Strictly Confidential

FEBRUARY 1980

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PME RESEARCH LABORATORY, FEBRUARY 1980

PROJECT TITLE : PRODUCT RESEARCH

PERIOD COVERED : JANUARY 28th - FEBRUARY 22nd

WRITTEN BY : P. GHISTE

SURFACE CHEMISTRY OF ADSORBENTS

New commercial adsorbents

- Some new adsorbents were characterized. One of them - charcoal from KEYSER & MACKAY (Sutcliff) - has interesting properties (1) :

Material code	Surface area (m^2/g)	Total pore Vol. (cm^3/g)	Mesoporous Vol. (cm^3/g)	Microporous Vol. (cm^3/g)
CA-196 (207 A)	940	0.38	0.08	0.30

- We were contacted by STEARKLE & NAGLER (WESTVACO) to test some new granular activated carbon.

- Asssitance was given to project Salamander II : adsorbent traps for selective filtration containing charcoal code CA-56 and Pittsburg CPG 14x40 impregnated with Salcomine (15 %) (2), were prepared.

ANALYSIS OF CO AND NO IN MAINSTREAM AND IN SIDESTREAM SMOKE

Set-up and testing of the instrument combination for determining CO and NO simultaneously in mainstream and in sidestream smoke of cigarettes was completed (Fig. 1).

Cigarettes are smoked in a pear-shaped glass smoke chamber (volume 1570 cm^3) at an air flow rate of 1.5/min. (3).

NO is determined by using the same arrangements of instruments reported recently (Fig. 1) (3).

The vapor phase of mainstream and sidestream smoke is collected in teflon gas bags and CO measured by two CO meters (Ultramat-Borgwaldt/mainstream smoke and Leybold-Heraeus/sidestream smoke).

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Source: https://www.industrydocuments.ucsf.edu/docs/yxnl0000

REFERENCES

(1) P. Ghiste, Notebook 791209, p. 1 (1980).
(2) P. Ghiste, PME Research Laboratory, Monthly Progress Report, August 1979.
(3) P. Ghiste, PME Research Laboratory, Monthly Progress Report, December 1979.

P. Ghiste

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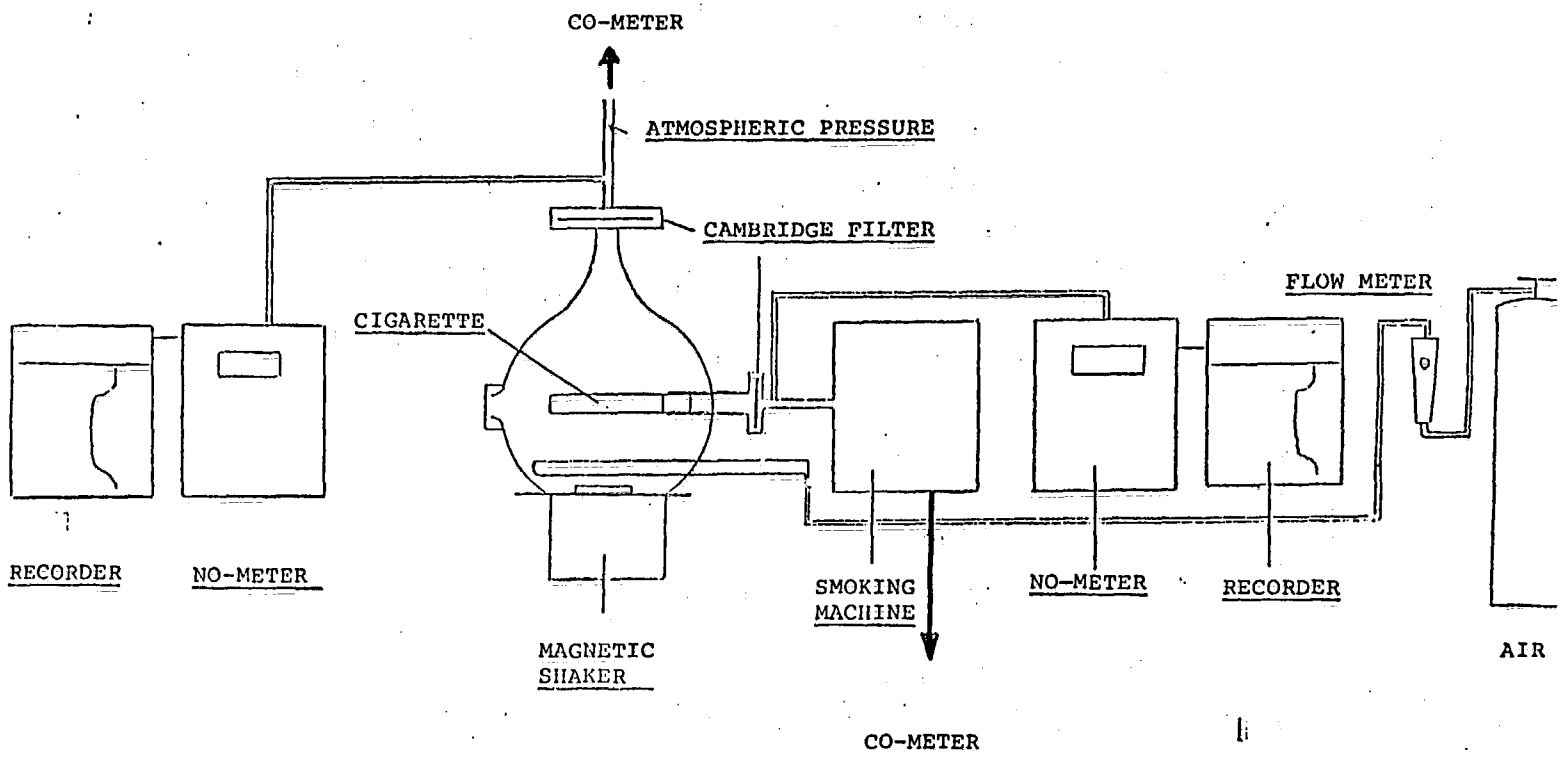
FIGURE 1



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PME RESEARCH LABORATORY, FEBRUARY 1980

PROJECT TITLE : PRODUCT RESEARCH

PERIOD COVERED : FEBRUARY 1980

WRITTEN BY : Y. GENOUD

GAS CHROMATOGRAPHIC INVESTIGATIONS.

- Assistance was given to P. Ghiste for gas phase analysis by capillary gas chromatography (Investigations on "Meerschaum") (1)

- At the request of QC (2), the applicability of several types of capillary columns to routine triacetin determination has been tested. Promising results have been obtained with fused silica capillary columns (high resolution, reduced analysis time).

  Fig. 1 depicts the gas chromatogram of a commercial mixture of mono-, di- and triacetin obtained with a fused silica capillary column (12 m x 0.2 mm; SP 2100), showing the separation of monoacetine and diacetin isomers.

- A new HP-5880A gas chromatograph (double channels with two capillary columns) was set up and four different fused silica capillary columns were tested.

REFERENCES

(1) P. Ghiste, PME Research Laboratory Monthly Progress Report, January 1980

(2) Verbal request of A. Widmer.

Y. Genoud

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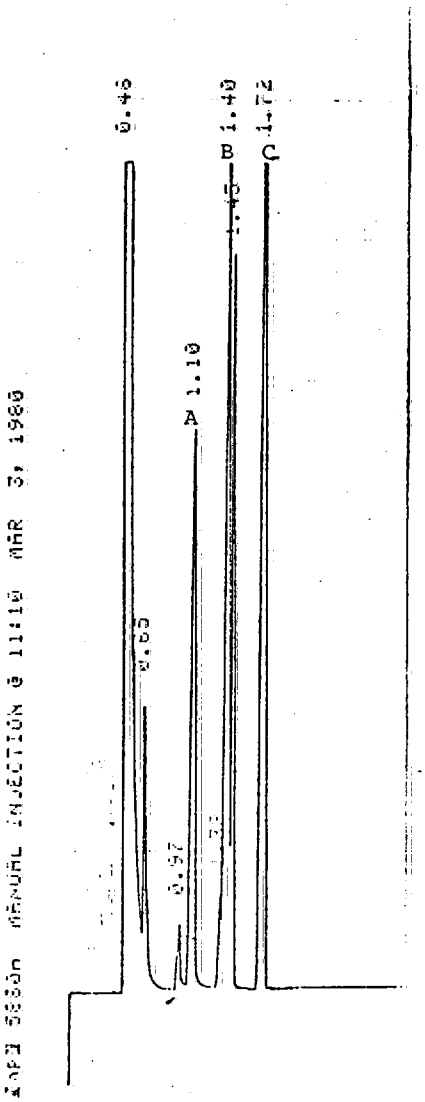
Fig. 1 Separation of Mono(A)-, Di(B) and Triacetin (C) by Capillary Gas Chromatography.



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PME RESEARCH LABORATORY, FEBRUARY 1980

PROJECT TITLE : PRODUCT RESEARCH

PERIOD COVERED : JANUARY 28th - FEBRUARY 22nd

WRITTEN BY : J. BOURQUIN

INSTRUMENT DEVELOPMENT

- The HP-9825-S calculator which will serve as data acquisition system for QC's CO/NO analyzer has been received. The study of operating and programming of the instrument has begun.

- NO Analyzer :

  The vacuum pumps of three NO meters have been dismantled in order to examine the conditions of the pumps after some time of operation. They were found in a rather clean and good condition, probably due to the permanent exposure to ozone.

  All normal O-rings have now been replaced by ozone resistant units.

J. Bourquin

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PME RESEARCH LABORATORY, FEBRUARY 1980

PROJECT TITLE : ANALYTICAL INVESTIGATIONS

PERIOD COVERED : JANUARY 28th - FEBRUARY 22nd

WRITTEN BY : F. MOSER

VOLATILE NITROSAMINES

DMN in ambient smoke

The concentration of DMN and of CO (1) in ambient smoke was determined.
Samples were taken in offices, conference rooms and in a discotheque. Results are summarized in Table 1.

DMN concentrations in offices 1 to 3 are not realistic in terms of human exposure to tobacco smoke. Window and door were kept closed during the sampling period (two hours) and people were forced to smoke the maximum amounts of cigarettes.

- DMN concentrations found are between 0.02 and 0.08 ng/l. Values as high as 0.24 ng DMN/l as reported elsewhere (2) could not be confirmed.
- CO values monitored correspond to values measured by Grandjean et al. (3) in enclosed environments.
- The factor DMN/CO which was found constant at 0.3 under experimental conditions (1) varies between 0.58 and 0.93 when determined under realistic conditions and in non-ventilated rooms.
- Noteworthy is the high concentration of N-nitroso-diethylamine (DEN) detected in some experiments. In sidestream- and mainstream smoke of cigarettes DEN is found in minor concentrations.

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SERVICES FOR OTHER GROUPS

53 lots (TLA) were analyzed for ISH.

REFERENCES

(1) F. Moser, PME Research Laboratory, Monthly Progress Report, November 1979

(2) K. Brunnemann et al., Amer. Chem. Soc. 1978, 876

(3) E. Grandjean et al., Int. Arch. Occ. Environ. Hlth. 41, 267 (1978).

F. Moser

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Source: https://www.industrydocuments.ucsf.edu/docs/yxnl0000

Table 1. CONCENTRATION (NG/L) OF DIMETHYLNITROSAMINE (DMN) IN AMBIENT SMOKE

	Pers. present	Cig. smoked	DMN	DEN[a]	DMN / CO PPM x 100
Office (1)	3	28	0.08	n.d.[b]	0.88
Office (2)	3	25	0.13	n.d.	0.86
Office (3)	3	35	0.15	n.d.	0.93
Office	2	12	0.02	0.01	0.90
Conference room [c]	12	37	0.02	0.002	---
Conference room	36	--	0.04	---	1.33
Discotheque	30-75	--	0.07	0.2	---
Office	6	27	0.03	0.03	0.58
Office	4	26	0.04	n.d.	0.58
Office	7	18	0.08	n.d.	2.20 (!)

a) N-nitroso diethylamine (ng/l)

b) not detected

c) ventilated room

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PME RESEARCH LABORATORY, FEBRUARY 1980

PROJECT TITLE : ANALYTICAL INVESTIGATIONS

PERIOD COVERED : JANUARY 28th - FEBRUARY 22nd

WRITTEN BY : E. LECOULTRE

GC/MS RESEARCH

Triacetin ESTROBOND B

Triacetin containing the same amount of glycerol-propionate-diacetate isomer mixture as ESTROBOND B (1) was synthesized by treating glycerol with a mixture of acetic and propionic anhydride (molar ratio 100:99:1) at 139° for 1 hour.
The product will be forwarded to QC for testing as filter additive.

Glycerol-propionate-diacetate isomer synthesis

Glycerol-2-propionate-1,3-diacetate (3) :

$ClCH_2CH(OH)CH_2Cl + CH_3CH_2COCl \xrightarrow{\text{reflux / 1 h}}$

$ClCH_2CH(OOCCH_2CH_3)CH_2Cl$ (1) + HCl

(1) : $C_6H_{10}Cl_2O_2$ (185); MS : 135($M - CH_2Cl$, 17), 75($CH_3CH_2COOH_2$, 53), 57(CH_3CH_2CO, 100), 49(CH_2Cl^{35}, 13), 29(CH_3CH_2, 24); yield 95 % (GC).

(1) + $CH_3COOK \longrightarrow CH_3COOCH_2CH(OOCCH_2CH_3)CH_2Cl$ (2) + KC

(2) + $CH_3COOK \not\longrightarrow CH_3CH_2COOCH(CH_2OOCCH_3)_2$ (3) + KCl

The reaction of (1) with 2 mole of potassium acetate in refluxing ethanol/24 h gave (2) in ~5 % yield; (3) was not formed.

(2) : $C_8H_{13}ClO_4$ (208); MS : 173($M - Cl^{35}$, 1), 159($M - CH_2Cl$, 3) 57($CH_3CH_2CO^+$, 100), 43(CH_3CO, 54), 29(CH_3CH_2, 18).

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$ClCH_2CH(OH)CH_2Cl + 2\ CH_3COOK \longrightarrow (CH_3COOCH_2)_2\ CH(OH)$ (4) + 2 KCl

Treatment of 1,3-dichloro-2-propanol with 2 moles of potassium acetate in refluxing ethanol yielded 80 % (GC) (4).

(4) : $C_7H_{12}O_5$ (176); MS: 103(M- CH_3COOCH_2, 33), 74($CH_3CO(OH)CH_2$, 74), 43(CH_3CO, 100).

The reaction of (4) with propionic anhydride to (3) is in progress.

AMINO ACID ANALYSIS

Efficiency of protein hydrolysis

Six probes of pure lysozyme protein of known amino acid profile (2) were hydrolyzed under conditions applied for yeast hydrolysis (6N HCl, 110°C, 48 h) and the individual amino acids analyzed. The number of amino acids per mole lysozyme found, %-recovery and standard deviation s are summarized in Table 1.
As can be seen most of the values obtained for the composition of lysozyme are in good agreement with those reported (2).

REFERENCES

(1) E. Lecoultre, PME Research Laboratory, Monthly Progress Report, January 1980.

(2) L.B. James, J. Chromatogr. 68 (1972) 123.

E. Lecoultre

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Source: https://www.industrydocuments.ucsf.edu/docs/yxnl0000

Table 1. Amino acid composition of Lysozyme; efficiency of protein hydrolysis

Amino acid	Lysozyme		%	s[b]
	No. of amino acids per mole of protein (2)	No. of amino acids per mole of protein found[a]		
Try	6	--	--	--
Lys	6	5.8	97.3	8.0
His	1	1.4	137.2(!)	10.1
Arg	11	12.7	115.1	3.7
Asp	21	22.6	107.6	5.7
Thr	7	6.9	98.2	4.3
Ser	10	9.5	94.9	5.8
Glu	5	5.3	106.4	4.1
Pro	2	3.4	170.0(!)	9.6
Gly	12	13.1	109.3	4.3
Ala	12	12.3	102.9	5.5
½Cys	8	2.9	36.7(!)	1.9
Val	6	6.8	113.3	5.6
Met	2	2.2	109.9	3.2
ILe	6	5.73	95.6	3.7
Leu	8	8.5	106.9	0.8
Tyr	3	3.2	107.9	5.0
Phe	3	3.1	101.9	4.6

a) Mean value of six protein analyses

b) 18 injections

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PME RESEARCH LABORATORY, FEBRUARY 1980

PROJECT TITLE : AGRICULTURAL CHEMICALS

PERIOD COVERED : FEBRUARY 1980

WRITTEN BY : M. SPECK

ROUTINE ANALYSES

Number of samples analyzed for pesticide residues :

Organochlorines	64	
Organophosphorus	64	(+ 4 samples with Methamidophos)
Dithiocarbamate	59	
Maleic Hydrazide	17	
Ridomil	53	

Ridomil has been analyzed on a routine basis for the first time.

NEW ANALYTICAL METHODS

Determination of Aldicarb :

Analytical work for joint experiments of the CORESTA Pesticide Sub-Group, decided at the CORESTA-meeting in Athens, November 1979 (1), has started.

REFERENCES

(1) M. Speck, PME Research Laboratory, Monthly Progress Report, October 1979.

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Source: https://www.industrydocuments.ucsf.edu/docs/yxnl0000

PME RESEARCH LABORATORY, FEBRUARY 1980

PROJECT TITLE : BIOTECHNOLOGY

PERIOD COVERED : FEBRUARY 1st - 29th, 1980

WRITTEN BY : D. SCHULTHESS

Nitrate electrode (1)

An Orion nitrate electrode is currently under test. The company claims that one can measure continuously the nitrate content in liquids.

Acid consumption (2)

Trials of the pilot plant showed different results concerning the acid consumption in the NINO-process than those we have found in the laboratory. We therefore determine these values again at different pH-values and initial phosphate concentrations. We could confirm the consumption of 31 g phosphoric acid (35 %) per liter of denitrated extract at a pH of 4.0. This value is independent of the dilution rate.

O_2/CO_2-Measurement (3)

Having still some troubles with our CO_2/O_2 determination in the off-gas of fermenters we set up a continuous denitration using a synthetic culture medium. In this trial we could show that we need at least 3 days to reach true steady-state conditions. It however has to be mentioned that the denitration is also working without having a true steady-state. We try now to have analogous trials done in the laboratory and pilot plant fermenters

Cellulase (4)

The production of cellulase by Trichoderma viride DSM 769 was further tested. An addition of glucose at a maximal level of 0.2 % increases the yield of this enzyme. The same is true by using Tween 80 in a concentration between 0.1 and 0.5 %.

Freeze-dryer

The freeze-dryer has been received and tested. We are able to produce freeze-dryed Ninomass and can now cover the needs of the Richmond flavor department.

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Miscellaneous

- An annual report is in preparation and will be distributed in March.
- The particle size distribution of a sepiolithe powder was determined by coulter counter (request of M. U. Nyffeler).
- Media for tissue cultures were prepared as a service for an extramural project.

References

1. J. Berney, Notebook 128, p. 39.
2. M.-F. Mangilli, Notebook 791205, p. 9-14.
3. J. Berney, Notebook 128, p. 36-38.
4. A. Hänggi, Notebook 790904, p. 25-28.

Schulthess

D. Schulthess

0001436772

Source: https://www.industrydocuments.ucsf.edu/docs/yxnl0000

PROJECT TITLE : Nitrate Reduction by Controlled Fermentation

PERIOD COVERED : January 28th - February 29th, 1980

WRITTEN BY : C. Ruf

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1. Trials

1.1. Trial NINO 53

The goal of the trial 53 which ran from February 4th to 8th was the training of the new operators who worked in 3 shifts, supervised by the pilot plant personnel. Less analyses than usually were made, because our attention was focused mainly on the practice. Nevertheless a total nitrate reduction was achieved during the main part of the trial.

1.2. Trial NINO 54

The trial NINO 54 ran from 12th to 20th February in order to present the pilot plant in operation to Messrs. B. Semp, B. Poorbaugh and H. Burnley from Richmond. The fermenter was cooled down during the week-end and started again on Monday the 11th of February without problems. A total nitrate reduction was achieved before and after the week-end.

1.3. Trial NINO 55

The trial NINO 55 has been running since February 25th and will continue until the end of the first week of March (the fermenter will be cooled down during the week-end).
The objective of this very important trial is to treat the RL-feedstock sent by R + D PM USA in order to produce three different extracts which will be returned to Richmond for sheet making (Ref. 1). Conclusions and results will be available in next month's report.

2. Pilot Plant

See monthly report : "Pilot Plant Operations", February 1980, C. Ruf.

3. NINO/RCB trials

See monthly report : "Reconstituted Tobacco II", February 1980, A. Robbiani.

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Source: https://www.industrydocuments.ucsf.edu/docs/yxnl0000

4. Nitrate Reduction of Strips

See monthly report : "Unit Operations II", February 1980, P. Karbacher, N. Lüthi.

5. NINOMASS

See monthly report : "Unit Operations I", February 1980, P. Karbacher.

6. Miscellaneous

6.1. The undersigned went to Richmond from January 29th to February 6th to visit the R + D Center and different plants (RCB, Park 500, etc...). He participated in the denitration meeting and discussed the comparative trial which is still running now in the NINO pilot plant.

6.2. As mentioned above (§ 1.2.), Mr. B. Semp (R + D Richmond) H. Burnley (Engineering Richmond) and B. Poorbaugh (Park 500) came to Neuchâtel on February 15th in order to visit the pilot plant and to collect some informations concerning the NINO process (Ref. 2).

6.3. The final reports on NINO trials 46 to 52 and the annual report were written by B. Krasna.

7. References

Ref. 1 : Letter to H. Friedrich from G. Gellatly, February 20th, 1980, "Denitration Processes Comparison".

Ref. 2 : Memo to H. Friedrich from B. Krasna, February 20th, 1980, "Visit of H. Burnley, B. Poorbaugh and B. Semp to FTR".

PROCESS DEVELOPMENT

C. Ruf

March 3rd, 1980
CLR/sde

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Source: https://www.industrydocuments.ucsf.edu/docs/yxnl0000

PROJECT TITLE : Pilot Plant Operations

PERIOD COVERED : January 28th - February 29th, 1980

WRITTEN BY : C. Ruf

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1. Equipment

1.1. Extraction

1.1.1. Since trial NINO 54 the stems are broken in the primary (threshing) instead of being hammermilled in the pilot plant. The hammermill was moved away in order to have more space for the rented strips extractor.

1.1.2. A new basket filter was installed to clean up the liquor at the outlet of the extractor.

1.2. Drying

In order to reduce the ambiant heat in the pilot plant, a suction hood was installed above the dryer. It seems to be efficient but it prevents checking on an eventual smoke emission (if the stems are overheated for example). The installation of a smoke detector is being studied.

1.3. Evaporation

During the trial NINO 54 a paddle of a vacuum-pump broke. The wheel was summarily repaired and will be replaced as soon as the ordered spare part arrives.

1.4. Control

Due to a wrong electrical wiring the extract flow integrators were slightly damaged and had to be returned to the supplier. At the beginning of trial NINO 55 they were re-installed and functioned correctly.

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2. Personnel

A lab technician apprentice, Mr. J.-L. Favre, began work in our laboratory on February 27th. He will be occupied in the pilot plant until the end of April, as a part of his training program.

PROCESS DEVELOPMENT

C. Ruf

March 4th, 1980
CLR/sde

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Source: https://www.industrydocuments.ucsf.edu/docs/yxnl0000

PROJECT TITLE : Unit Operations I

PERIOD COVERED : January 26th - February 29th, 1980

WRITTEN BY : P. Karbacher

NINOMASS

The results of the amino-acid determinations of the NINOMASS were received. One analysis was carried out in our own labs, the other was made in an external lab (Ref. 1). Comparing the results we noticed some discrepancies. Some values of individual amino-acids correspond very well, some others do not. A second comparative analysis will be carried out.
According to VLGZ (a potential buyer for dried NINOMASS, to be used for animal feed) three amino-acids are important for their purpose, these are : Lysine, Methionine and Cystine. The price which VLGZ is willing to pay depends on the content of crude-proteine and the presence of the above mentioned three amino-acids.

Our efforts to find a pilot scale drying unit for NINOMASS continued. Aeromatic in Basel offers different systems for rent. A visit is scheduled to discuss the details.

References

Ref. 1 : Untersuchungsbericht No. 5800; Rob. Ehrismann AG, 5200 Windisch; February 21st, 1980.

PROCESS DEVELOPMENT

P. Karbacher

March 3rd, 1980
KPA/sde

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Source: https://www.industrydocuments.ucsf.edu/docs/yxnl0000

PROJECT TITLE : Unit Operations II

PERIOD COVERED : January 26th - February 29th, 1980

WRITTEN BY : P. Karbacher, N. Lüthi

Nitrate Reduction of Strips

The pilot plant scale extractor arrived mid February. In the week from February 18th to 22nd Mr. Jess from Ex-Technik was present in Neuchâtel for the start-up of the equipment. The 12 cells (chambers) of the rotor are used as follows :

Cell 1	:	Feeding (strips inlet)
Cell 2 - 3	:	Pre-humidification of strips
Cell 4 - 9	:	5 stage counter-current extraction
Cell 10	:	Dewatering zone
Cell 11	:	Strips outlet
Cell 12	:	Empty zone

Already the first trials (under Mr. Jess's supervision) showed positive results. The rotocell-extractor treats the strips very carefully. Now we are carrying out trials under different working conditions (temperature, strips to water ratio, extraction time).
In summary we obtained the following first results :

NO_3-N reduction of strips	extr. time	temperature	strips : water
93 %	40 min.	80°C	1 : 10
88 %	40 min.	50°C	1 : 10
95 %	40 min.	80°C	1 : 15
90 %	40 min.	50°C	1 : 15
85 %	20 min.	80°C	1 : 10
75 %	20 min.	50°C	1 : 10

At 40 minutes residence time the use of more water for extraction (1 : 15 instead of 1 : 10) increases the NO_3-N reduction of the strips by only 2 %.

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Source: https://www.industrydocuments.ucsf.edu/docs/yxnl0000

Dust sieving for MONIQUE/RCB

Contact was taken with Chauvin in Grenoble, supplier of the sieving machine in Onnens.

A representative of this firm visited Onnens on February 19th to find a solution to the clogging problems of the lower sieves (100 mesh steel web).

Chauvin's operational experience on similar materials is that the product moisture plays an important role. The average moistures of the production dust in the silo are between 8 and 9% O.V.
If the dust were dried (3 - 4% O.V.) before sieving the clogging problems would be significantly reduced.

The conclusion is that the sieves have to be cleaned from time to time, if necessary every day (normally once a week). To ease this operation a complete sieving frame should be ordered. Chauvin will send us an offer. They will hopefully propose other improvements.

Dust stock situation

The dust stock in Onnens continued to decrease in February to approx. 126 tons.

PROCESS DEVELOPMENT

P. Karbacher N. Lüthi

March 4th, 1980
KPA/NIL/sde

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Source: https://www.industrydocuments.ucsf.edu/docs/yxnl0000

PROJECT TITLE : Reconstituted Tobacco II

PERIOD COVERED : January 24th - February 29th, 1980

WRITTEN BY : A. Robbiani

MONIQUE / RCB
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Production

During this month 39'400 kg of sheet were produced : a production record. With respect to the overall working hours this represents an increase of 16.7% on the January production of 31'400 kg.
The increase of production was mainly due to :

- reduction of cleaning time
- reduction of start-up time on Monday due to storage of solution over the week-end
- better overall efficiency.

Slitter cutter (Ref. 1)

The results of the comparative test (COMAS cutter vs FTR prototype cutter) showed no significant differences in performance of the two machines.
As the COMAS cutter needs more maintenance and generates more noise it will be replaced. The FTR Engineering department is in charge of the study (drawings, price, etc...).

LUWA Ventilation System (HVAC)

The exhaust air duct was modified by LUWA on January 26th. The reason for this modification was to dislocate the air outlet from the air intake duct.
An additional suction system was installed underneath the Sandvik steel belt (return strand) on February 4th and 5th.
As a result the conditions of the ambient air with respect to the ammonia content are in general acceptable, but there are still certain areas where ventilation should be increased.
A suction hood on the transfer belt will be added between the two dryers.

0001436680

Source: https://www.industrydocuments.ucsf.edu/docs/yxnl0000

Roll coater

After having changed the rubber roll of the roll coater on January 11th we noticed a substantial improvement of slurry application and of sheet aspect.

After dryer

Some heating elements in the after dryer "BAFAG" have already been replaced several times. These problems were discussed with engineers from BAFAG. They proposed to install improved elements which are able to support higher ambient air temperatures.

Pumps

We finally decided to replace the membrane pumps by Moyno pumps. This will eliminate the problems with pulsating flows and frequent pump maintenance.
One Moyno pump has been running from November 9th, 1979, to our entire satisfaction.

Sandvik dryer

The FTR Engineering department (M. Regard) is carrying out different trials during production to better understand the overall performance of the Sandvik dryer (heat transfer, evaporation + air flow rates, etc...). The final objective of these studies is to try to increase the dryer capacity.

Dust stock situation, dust sieving

See monthly report, February 1980, Unit Operations II, N. Lüthi.

3.4% MONIQUE/RCB in MLF blend

The decision to use 3.4% MONIQUE/RCB in the FTR Marlboro blends as from January 23rd was made.

Project situation (Ref. 2)

A complete situation report was established by the project leader, F. Boichat, on January 18th.
The project organization was redefined. The tasks were clearly distributed to different people.

0001436B1

Source: https://www.industrydocuments.ucsf.edu/docs/yxnl0000

Cost situation (Ref. 3)

A detailed product cost analysis was finished on January 28th.
The objective was to compare projected product costs (8/77) with present costs.
These are 25.6% higher than projected two years ago.

Application of NINO-products in MONIQUE/RCB

Trial NINO/RCB 2

In this trial the stem part, representing 44% of the total feedstock blend, was replaced with washed NINO stems (Lot No. 7999) and the corresponding denitrated extract was added. Here is the summary of the analytical results (Ref. 4) :

a) Sheet

We notice an average thickness of 0.233 mm and a sheet weight of 149.6 g/m^2 at 13.2% O.V. (=129.9 g/m^2 dry weight).
The current November production showed 0.186 mm resp. 138.4 g/m^2 at 13.5% O.V. (=119.7 g/m^2 dry weight).
This difference is due to casting roll adjustments.

The free burning rate is 8.8%, the one of the November production was 12.8%.
This was expected due to the phosphate content of the denitrated, concentrated (33.5% TS) extract that contains approx. 110 g/l of PO_4 .

The only objective of this trial was to determine the feasibility of the application of NINO products in Monique/RCB. Therefore no adjustments in additives to compensate for the phosphate were considered.

Phosphate in sheet NINO/RCB 2 : 7.3%

Phosphate in sheet of current production : 3.8%

0001436B2

Source: https://www.industrydocuments.ucsf.edu/docs/yxnl0000

b) Cigarettes (100% sheet)

A relatively low DPM value was noticed (12.9 mg/g versus 18.9 mg/g on normal production).
This was unexpected and we are trying to find an explanation.
As some difficulties with the machine smoking of the cigarettes occurred due to poor combustion the results are doubtful.
For the reasons mentioned above CO, NO and puff numbers could not be obtained.

Nitrate-nitrogen was 0.18% in the test sheet (0.25% in current production).

QC Onnens
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Lab installation

Some lab equipment was ordered : scales, ovens and alu boxes for tobacco samples.

Offers for the lab installation (furniture) were received from two different firms and are being studied.

Personnel

Two lab-technicians are foreseen. One is already working in the Monique/RCB lab, the second has still to be found.

References
==========

1) Memo from A. Robbiani : Rapport sur l'essai comparatif coupeuse pour feuille Monique/RCB entre la coupeuse COMAS et la coupeuse FTR prototype, February 20th, 1980.

2) Presentation Monique/RCB by F. Boichat, January 18th, 1980.

3) Projet Monique/RCB, coûts by F. Boichat, January 28th, 1980.

4) Résultats analytiques de l'essai RCB-NINO No. 2 from L. Joseph to A. Robbiani, February 25th, 1980.

PROCESS DEVELOPMENT

A. Robbiani

A. Robbiani

March 4th, 1980
ARO/sde

0000143683

Source: https://www.industrydocuments.ucsf.edu/docs/yxnl0000

PROJECT TITLE	:	APL - PME CIGARETTE DATA BANK
PERIOD COVERED	:	January 26th - February 29th 1980
WRITTEN BY	:	R. TOIMIL

During February 1980 five inputs for criteria recording in the PME Cigarette Data Bank were created.

These inputs are the following :

1) Projects Area, Operations and Product Research (See enclosure 1)
2) Blend, Solutions and Processing (See enclosure 2)
3) Cigarette Specifications and Sample Order (See enclosure 3)
4) Filter Specifications and Sample Order (See enclosure 4)
5) Technical Sheet (See enclosure 5)

A report explaining and describing each criterium and how to use these inputs will be distributed during the first week of March.

The concept of the different outputs concerning the general characteristics of a project (blend, solutions, cigarette specifications, as well as the card-indices of filters and material codes) has been structured.

The general concept will be ready and presented by mid-March.

R. Toïmil

05/03/1980/RAT/cap

00014684

Source: https://www.industrydocuments.ucsf.edu/docs/yxnl0000

PROJECTS AREA, OPERATIONS AND PRODUCT RESEARCH

Request issued by : . . . . . .
Addressed to : Miss Catherine Porchet, PME Product Dev., CH-2003 Neuchâtel
Entry approved by : U. Nyffeler . . . . . (requests type A and R)
Entry approved by : J.-B. Boder . . . . . (requests type O)

372 PROJECT NAME

373 PROJECT NO

139 BLEND TYPE

136 PRODUCTION CENTER

138 NO/PACK

137 COUNTRY OF SALE

140 TYPE OF PACK

295 CIGARETTE TOTAL LENGTH

296 FILTER LENGTH

297 CIGARETTE DIAMETER

144 PROJECT LEADER

145 DEVELOPMENT OF NEW PRODUCT

135 PROJECT WITHDR./INACT.

146 EXISTING BRAND ON NEW MARKET

143 PRODUCT LAUNCHED

147 MODIF. EXIST. BRAND - LEVEL BLEND

141 DATE OF REQUEST

148 MODIF. EXIST. BRAND - LEVEL FILT./CIG.

312 PRIORITY

149 MODIF. EXIST. BRAND - LEVEL PACK-BUNDLE

309 PRODUCT CANDIDATE READY

310 PRODUCT TEST READY

311 WHERE

150 OBJECTIVE(S)

OFFICIAL BRAND NAME(S)

REMARKS

00014368S

Source: https://www.industrydocuments.ucsf.edu/docs/yxnl0000

BLEND, SOLUTIONS AND PROCESSING

373 PROJECT NO | 372 PROJECT NAME

172 BLEND NO | 173 PROCESSING VERSION

	EXPANDED STEMS		RECONSTITUTED		EXPANDED TOBACCO		ADDITIVE STEMS	
	154 TYPE	153 %	156 TYPE	155 %	158 TYPE	157 %	160 TYPE	159 %
A								
B								
C								
D								
E								
F								

	%		%		%		%
312 FC US		313 REMOVED STEMS		320 MARYL.		321 REMOVED STEMS	
314 FC		315 REMOVED STEMS		322 AIR-CUR.		323 REMOVED STEMS	
316 BURLEY US		317 REMOVED STEMS		324 ORIENT			
318 BURLEY		319 REMOVED STEMS					

	(L)	NAME	MATERIAL CODE	
162 BURLEY CASING			163	
164 BURLEY TOP FLAVOUR			165	
166 PC			167	
168 AC			169	

161 TREATED BURLEY (%)

171 EXCEPTIONS

170 PROCESSING ACCORDING TO SPECS

MOISTURE REPORT

	NO	SPECS	RESULTS	MINI	MAXI
AFTER BURLEY CASING	180	181	182	183	184
AFTER BURLEY	185	186	187	188	189
CUT STEMS	190	191	192	193	194
SUPER WETTING	195	196	197	198	199
BLENDED STEMS	200	201	202	203	204
STRIPS	205	206	207	208	209
CUT LEAF	210	211	212	213	214
CUT RAG	215	216	217	218	219
BEFORE TOWER	220	221	222	223	224
EXPANDED STEMS	225	226	227	228	229

325 STORAGE TIME MINI (Hours)

326 STORAGE TIME MAXI (Days)

0001436B6

Source: https://www.industrydocuments.ucsf.edu/docs/yxnl0000

CIGARETTE SPECIFICATIONS AND SAMPLE ORDER

To : Mr. R. Schorpp
From :

Order No :
Date of Order :

copies : URN / RUG / RAT / SEB (2X)

373 PROJECT NO

372 PROJECT NAME

144 PROJECT LEADER

174 CIGARETTE NO
172 BLEND NO

173 PROCESSING VERSION
295 CIGARETTE LENGTH
296 FILTER LENGTH
PARTIE NO (FTR)
TIPPING LENGTH
ACCU-RAY WEIGHT (YES/NO)

FORMAT

SKIP-TIP (YES/NO)

30

MATERIALS

175 FILTER CODE / NAME

176 CIGARETTE PAPER CODE / NAME

177 TIPPING PAPER CODE / NAME

178 GLUE SEAM CODE / NAME

179 GLUE TIPPING CODE / NAME

308 DATE OF PRODUCTION

QUANTITY
DIAMETER
TOTAL WEIGHT
CIGARETTE ROD WEIGHT

Source: https://www.industrydocuments.ucsf.edu/docs/yxnl0000

372 PROJECT NAME

FILTER SPECIFICATIONS AND SAMPLE ORDER

Quantity :

To : Mr. R.SCHORPP
From :

Order No :
Date of Order :

copies : URN / RUG / RAT / SEB (2X)

Date of production :

175 MATERIAL CODE

		PLUG 1	PLUG 2	PLUG 3	PLUG 4	COMBINED
DIAMETER (mm)	327	328	329	330		245
TOTAL ROD LENGTH (mm)	331	332	333	334		246
PLUG LENGTH (mm)	335	336	337	338		142
R T D (mm WG)	339	340	341	342		256
FILTER MATERIAL (mg) A	247	343	344	345		
PLUG WRAP + ADHESIVE (mg) B	248	346	347	348		349
PLASTICIZER (mg)	249	350	351	352		
PLASTICIZER OF A + B = C (%)	250	353	354	355		PSP
ADDITIVE 1 (mg)	251	356	357	358		374
ADDITIVE 2 (mg)	252	359	360	361		375
ADDITIVE 3 (mg)	362	363	364	365		
TOTAL WEIGHT (mg)	366	367	368	369		370

MATERIAL CODE

PLUG WRAP	260	CODE / NAME
FILTER MATERIAL	257	CODE / NAME
PLASTICIZER	258	CODE / NAME
ADDITIVE 1	259	CODE / NAME
ADDITIVE 2	379	CODE / NAME
ADDITIVE 3	379	CODE / NAME
GLUE INNER	261	CODE / NAME
GLUE SEAM	262	CODE / NAME

PSP 376 377

380

381

- 31 -

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TECHNICAL SHEET

434 NO
435 DESIGNATION
436 FOURNISSEUR

402 LONGUEUR DE BOBINE
403 LARGEUR
404 GRAMMAGE
405 EPAISSEUR
406 VERGEUR
407 POIDS SPECIFIQUE
408 POROSITE
409 TYPE DE POROSITE
410 BLANCHEUR
411 OPACITE
412 RESISTANCE A LA RUPTURE
413 ALLONGEMENT
414 TENEUR EN CENDRES
415 VITESSE DE COMBUSTION
416 ABSORPTION D'EAU

417 RUGOSITE
418 COULEUR D'IMPRESSION
419 POSITION DE LA PERFORATION
420 LARGEUR DE LA PERFORATION
421 LIGNES DE PERFORATIONS
422 GRANDEUR DES TROUS
423 LIGNES D'IMPRESSION
424 LARGEUR D'IMPRESSION
425 MATERIEL DE FILTRATION
426 DENIER PAR FILAMENT
427 DENIER TOTAL
428 DENIER NOMINAL
429 SECTION TRANSVERSALE
430 COULEUR
431 ONDULATION

432 COMMENTAIRES

433 QUANTITE EN STOCK

FP : 23 / TP : 32 / CP à 30 / FM : 22

0001432689

Source: https://www.industrydocuments.ucsf.edu/docs/yxnl0000

PROJECT TITLE : CIGARETTE DEVELOPMENT, TECHNICAL REPORT
PERIOD COVERED : January 23rd - February 29th 1980
WRITTEN BY : R. HIRSBRUNNER

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335 LOLITA DB K = 10 / N = 0.8

In order to reach the new objectives, 8 versions have been made with the MARLBORO LIGHTS blend (13 % of ET) :

- versions 1, 2, 3 and 4 : without after cut
- versions 5 to 8 : with LARK flavour (standard PM)

Format : 7.975/25/84.4
The filter for this project has been made in FTR with the following specifications :

Total length : 100 mm
Diameter : 7.88 mm
Total RTD : 320 mm WG
Total weight : 1216 gr/1'000
Inner plug : 2.5/48'000 Y (MERIT tow)
Space : 6 mm with 100 mg Pica carbon
Outer tow : 5/54'000 Y
Plug wrap paper : Ecusta 634, mechanically perforated, heat sealing.

The progress report has been established and we are awaiting the Panel A's appraisal (sheet No H-128) for the versions 5 to 8 (1).

Next step : Filter making with Calgon carbon.

335 LOLITA DB K = 13 / N = 0.9

In order to improve the LARK flavour taste (fruity cake) two cigarettes were made in FTR with the MARLBORO PE blend and prototype 13 specifications :

Format : 7.975/20/84.4, dilution 20 %
Filter : Original PSP 20 mm LARK filter (Durham)

The progress report has been established (2).

Note : The version 20 is foreseen for taste improvement by A. Badstuber (flavour development PME) and the version 21 for flavour development by R & D in Richmond.

Next step : Flavour injections.

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250 COCKPIT BLUE CO-reduction and blend change

A trial repetition (Version 94) was made in Munich according to the Pan European trial specification versions No 91 :

Blend : MARLBORO PE (or Italy for Munich)
Paper : Mauduit 110-6 EP
Filter : 3.4/46'000 with FU-POV 40 L
Tipping : Benkert zone perforated Z3/60
Dilution : 15 %

Progress report : established (3).
Panel A : effected, sheet No H-136.
"It gives a good quality taste, soft, mild same direction as previous prototypes. In our opinion this is an improvement".

Next step : 1) Presentation at the next German project Meeting
2) Repetition with a filter length increase from 20 to 21 mm

340 GAMMA DB 4 and 6 mg tar / Product test

Due to the tremendous difficulties to obtain the tipping paper, the product test will be delayed once more.
New delivery date : End of March.

Next step : 1) Better prototypes will be presented to the German Marketing (versions 71 M / 73 D).
2) Prototypes specifications and flavour recipes will be given to G. Völkl as soon as possible.

334 ATLANTIC

MERIT 15 % of ETNA-1 (non US-FC)

The repetion of versions 5 and 6 has been made. The cigarettes are being evaluated by the smoking lab and Panel A.

Prototype specifications

Version	7	8
Format	7.95 / 25 / 84. 4	
Blend	HILTON Sweden/Benelux, batch 843	
Flavour	100 % MERA-AC	
Paper	Mauduit 753 bis	Mauduit 110-6
Tipping	32 mm, zone perforated Z4/100 (MERIT)	

Next step : Progress report.

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AMBASSADOR Step 80.21

In order to accelerate the MAA-ATLANTIC program, two cigarettes were made according to the first step 80.21 cigarette specifications :

Version	6	7
Format	7.975/18/79.4	
Blend	LOS ANGELES MAA, batch 845 (2 % of ETNA-2)	
Paper	Pela 54 M	Fletcher HP 5
Filter	LOS ANGELES, 70 % of Charcoal	
Tipping	Micro-laser 4 M. 0.15, 3 colours	

Results : Cigarettes are being evaluated by the smoking lab and Panel A.

350 PETER PAN L & M First production and diluted prototype Development

The report on the first production carried out in Munich for Italy has been established (4).
A diluted version is in preparation in FTR with the following specifications :

Versions No 8

Format : 7.95/18/79.4
Blend : MLF Pan Europe
Paper : Ecusta 753
Filter : 3.4/46'000 with porous plug wrap FU-POV 40 L
Tipping : Benkert Z3/60

350 PETER PAN LARK First production

The report on the first production carried out in Munich for Italy has been established (5).

192 BELTOISE FR First production

The report on the first production MURATTI EXTRA MILD France has been established (6).
The analytical results and the taste are in order.

342 TAMBAY PHILIP MORRIS SUPER LIGHTS First production

The report on the first production PMS in Munich for France has been established (7).
The smoke yield and the taste are in order.

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233 COUNTRY DB — Porous plug wrap trial

In order to choose the best PPW and to build up a stock as rapidly as possible for the city test, Berlin has carried out two trials on the basis of version 91 S :

Version	102 B	104
Blend	91 S (S for Strips)	91 S
Filter	3.0/43'000 Y	Rhodiaceta 21 mm
PPW	FU-POV 24 K	FU-POV 40 L
Paper	Pela 200	Pela 200

Results : The smoke yield is in favor for the FU-POV 40 L PPW (8).
Panel A : "No decision can be made concerning the FU-POV paper because both cigarettes are below quality and give less MLF character. In general the taste is almost monotoneous and not clean and lively enough".

Next step : The trials will be repeated with a fresh blend in Berlin.

336 MARY — KS air-cured cigarette for Germany

The samples of the trial program in Munich are on the way to Switzerland :

8 versions : 4 with blend storage in MARYLAND wood case (WMB)
4 with blend storage in "Carboard case" (CB)

Next step : Comparisons 1) between WMB and CB trials
2) between FTR trials and Munich

297 HILTON MENTHOL — Dilution concept modification

As soon as the prototype with zone perforated tipping paper Z4/100 is packed with the foil mentholating process, the sample will be submitted to :

Smoke lab
Analytical services (menthol determination)
Panel A

317 PROJECT " M " MILTI 100'S — K decrease (10 mg)

In order to lower the K value, two new filters have been made in FTR and sent to Munich.

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Filter specifications

Version	23	12
Black part (inner)	FU-POV 150 (Both with 70 % of charcoal and 4 % of triacetine)	FU-POV 40 L
White part	5.0/46'000 I	CEE tow with higher RTD
Plug wrap paper	FU-POV 40 L	FU-POV 40 L

Cigarette

Versions 23 and 24 : specifications according to MULTI 100'S (9).

315 NEWCASTLE WN Special trials

Cigarettes with printing die and pack for TV show presentations (London) have been prepared.

314 YORK WN Filter development / DPM = 20 mg

On the special triple filter maker (FTR) a new filter has been developed according to the following specifications :

Plug 1 (inner) = 3.4/46'000 I (5 mm)
Plug 2 (middle) = 5/40'000 X (6 mm) with 30 mg Polygel
Plug 3 (outer) = 3.4/46'000 I (5 mm)

2 x 4'000 filter plugs and 6 L of YK-AC-2 were brought to Illorin for trials and product test purposes.

R. Hirsbrunner

07/03/1980/RAH/cap

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Source: https://www.industrydocuments.ucsf.edu/docs/yxnl0000

REFERENCES

(1) LOLITA DB, K = 10, progress report from R. Hirsbrunner to W. Tschudin, dated March 4th

(2) LOLITA DB, K = 13, progress report from R. Hirsbrunner to W. Tschudin, dated March 4th

(3) COCKPIT BLUE DB, progress report from R. Hirsbrunner to W. Tschudin, dated March 4th

(4) Report of the first production L & M from R. Hirsbrunner to W. Tschudin, dated March 4th

(5) Report of the first production LARK from R. Hirsbrunner to W. Tschudin, dated March 4th

(6) Report of the first production BELTOISE from R. Hirsbrunner to W. Tschudin, dated January 20th

(7) Report of the first production PHILIP MORRIS SUPER LIGHTS from R. Hirsbrunner to W. Tschudin, dated March 4th

(8) Progress report COUNTRY DB from R. Hirsbrunner to W. Tschudin, dated February 19th

(9) Telex Project "M" from R. Hirsbrunner to G. Völkl, dated March 3rd

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Source: https://www.industrydocuments.ucsf.edu/docs/yxnl0000

PROJECT TITLE : CIGARETTE DEVELOPMENT, TECHNICAL REPORT
PERIOD COVERED : January 23rd - February 29th 1980
WRITTEN BY : P. NAGEL

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363 DELAWARE Swiss tar : 3.0 / Format : 25/80/7.95

In order to reach the Marketing objectives the development of this project will start in March on the following basis :

A) Maryland blend type containing 27 % of expanded tobacco ETNA-CH.

B) Concerning the cigarette supplies : a double filter, a PSP filter, cigarette papers from Schöller & Hösch and a micro-laser tipping paper will be tested.

Technical data of the filters

Double filter 100 mm (4 x 25 mm)

Tow : 2.5/48'000 Y, white / 5.0 / 40'000 X, black
Additive : Charcoal Pica 14/35, not very active
Paper : Schöller & Hösch, FU-POV 100 K
Total RTD : 340 mm WG

PSP 100 mm (4 x 25 mm)

Basic specifications : FLU - 120
Additives : Meerschaum 14/30 at 60 %
Charcoal Pica 14/35 at 40 %
Total RTD : 420 mm WG

271 COLORADO Swiss tar : 3.0 / Format : 25/84.4/7.95

As the first series of prototypes did not reach the smoke yield objectives, a new blend was created to reduce the total alcaloids.
The following cigarette supplies will be tested :

Technical data of the filters

Double filter 100 mm (4 x 25 mm)

A) Tow : 2.5/55'000 Y, white / 5.0 / 40'000 X, black
Additive : Charcoal Pica 14/35, not very active
Paper : Schöller & Hösch, FU-POV 100 K
Total RTD : 400 mm WG

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B) Tow : 2.5/48'000 Y, white / 5.0 / 40'000 X, black
Additive : Charcoal Pica 14/35, not very active
Paper : Schöller & Hösch, FU-POV 100 K
Total RTD : 340 mm WG

PSP 25 mm (4 x 25 mm)

Basic specifications : FLU - 120
Additives : Meerschaum 14/30 at 60 %
Charcoal Pica 14/30 at 40 %
Total RTD : 420 mm WG

Cigarette paper : Ecusta 708

Tipping paper : Micro-laser (Malaucene)

278 EVEREST

The problems concerning the Burrus patent with "Meerschaum" could not be solved. Therefore the firm Baumgartner was contacted for the production of a triple filter for the new FLINT, which will be launched beginning of May 1980.
The meeting with Baumgartner turned out to be positive : they can produce the new filter in a short period of time (Samples : end-February, first production : mid-April).

Triple filter characteristics

Configuration : 5/10/5 mm
Format : 7.80/120 mm
RTD : 440 mm WG

Plug 1 : Length : 80 mm / Diameter : 7.80 mm / Tow : 2.5/48'000 Y / Plastizicer : 10 % of Estrobond B / Paper : white, non-porous / RTD : 320 mm WG

Plug 2 : Length : 80 mm / Diameter : 7.80 mm / Tow : 5.0/40'000 X, black / Plastizicer : 8.5 % of CA-50- FI / Paper : FU-POV 40 L, porous / Additives : Meerschaum 14/30 at 60 %, Charcoal Pical 14/30 at 40 % /RTD : 210 mm WG

Plug 3 : Length : 80 mm / Diameter : 7.80 mm / Filter material : Dico CAF 250 paper / Paper : white, non-porous

Remark : The plugs 1 and 3 are produced with a non-porous plug wrap, as the plug 2 is used to make the dilution.

P. Nagel

00014369?

Source: https://www.industrydocuments.ucsf.edu/docs/yxnl0000

PROJECT TITLE : CIGARETTE DEVELOPMENT, TECHNICAL REPORT
PERIOD COVERED : January 22nd - February 29th 1980
WRITTEN BY : J.-H. DU BOIS

S W E D E N

354 INGEMAR / GAMMA — Product having a tar content of 6 to 8 mg/cig., an SN as high as possible, CO content below 10 mg/cig. and a puff count of 8 puffs/cig. A 25 mm filter and 29 mm tipping are requested.

Six prototypes giving DPM deliveries between 6.6 and 8.7 mg/cig. were produced by using micro-laser perforated and zone perforated tippings.
Two prototypes, No 5 and No 9, with DPM of 6.6 and 8.5 are interesting taste wise and will be reproduced with the GAMMA 83 E flavour at 70 %.

355 GOSTA I — A product delivering 1 mg tar or less, SN and CO values should be commensurately low, but are not specified. Same format as BOND LTN. Cork tipping. American blended type of taste.

Two trials were made by using the more efficient raw materials available (2.5/48'000 acetate ; FU-POV 150 K porous plug wrap ; 3 lines mec. perforated tipping), but the tar level of 1 mg/cig. was not reached.
Trials will therefore be made with dual paper/acetate filters which have the property of a higher efficiency for an identical RTD, in comparison to the single acetate filters.

361 GOSTA II — An American blend GAMMA type product delivering 2 and 4 mg tar. Moderate size.

Of the seven trials made recently (prototypes 24 to 30), three conclusions can be drawn.

a) Trials made with 60 K, 80 K and 100 K porous plug wraps on 3.4/46'000 I acetate filters gave respectively 6.8, 4.8 and 3.0 mg/cig. tar and a prototype should be produced with a 90 K plug wrap in order to achieve the 4 mg objective.
The total RTD is an acceptalbe 95 mm H_2O.

0001436 98

Source: https://www.industrydocuments.ucsf.edu/docs/yxnl0000

Trials will however be made with dual paper/acetate filters for the reasons given for GOSTA I.

b) As far as the flavour is concerned, an application at a concentration of 70 % of the GAMMA 83 E flavour is more interesting as the tobacco taste comes out more pronounced.

c) The blend modification using 17 % of ETNA and 10 % of ES instead of 27 % of ETNA makes the cigarette more aggressive, but it does not beat BLEND ULTRA.

U N I T E D K I N G D O M

208 TENNIS UK tar less than 16 mg/cig. / Format : 7.975/20/85

In order to compare the standard solution with the solutions according to the Hunter list, 8 prototypes were made with the MLF blend. The solutions being compared are the burley casings/top flavours, PC and AC.

290 HILTON UK tar less than 10 mg/cig.

Prototypes 39 to 41 will be tested in a product test.
The weak points which came out in the previous test were corrected by using a Fletcher MC HP 5 cigarette paper and by lowering the compacity.

F R A N C E

362 TAMBAY II = WATSON

This project will now be named WATSON.
Trials have been made with different flavour applications and the following trials were retained :
GAMMA 83 E at 100 % on prototype GAMMA 73, GAMMA 83 E at 70 % on prototype 73 and a mixture of GAMMA 83 D at 50 % with MF-AC basis at 20 % on prototype 71. This last trial is probably the optimum product.
Trials 73 D and 71 M will be tested against PETER STUYVESANT EXTRA MILD and CAMEL MILD.

J. Du Bois

J.-H. Du Bois

05/03/1980/JHD/cap

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Source: https://www.industrydocuments.ucsf.edu/docs/yxnl0000

PROJECT TITLE	:	FLAVOUR DEVELOPMENT
PROJECT LEADER	:	A. BADSTUBER
PERIOD COVERED	:	January 28th - February 26th 1980
WRITTEN BY	:	A. BADSTUBER

ASSISTANCE TO OTHER PROJECT LEADERS

- We worked on the projects ATLANTIC / COLORADO / GAMMA / GOSTA I AND II / HILTON UK / INGEMAR / LOLITA / MIAMI / PETER PAN / RUGBY / SPRINT / TAMBAY / TENNIS UK.

- 600 kg of tobacco were treated for nine different projects.

FOIL MENTHOLATING

- The first industrial production of MARLBORO MENTHOL was carried out in Munich at the end of January. The analyses of 36 packs of this production give the results :

  3.62 mg menthol/cig. with s = 0.07 mg menthol/cig.

  The losses of menthol are as expected : 15 %.

- We have started the trials for foil mentholated brands in Holland and Belgium. The bobbins have to be sent this week for the brands RUNNER MENTHOL, NORTH POLE and ARMADA MENTHOL.

- The procedure for ordering mentholated solutions has been established.

- The standardization of blend for BOND MENTHOL (45 BSC for 56 BSC) has been accepted by Panel A.

- We are now working on the blend standardization for CHECKER MENTHOL and on the standardization of solution for CHECKER MENTHOL and NORTH POLE.

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DRUM FOR LABORATORY FLAVOURINGS (1)

- The regularity of spraying has been improved by using nozzles spraying with an angle of 90° (instead of $60\ ^{o}$).

- The mixing of two different tobaccos is good up to 20 % (in case of mixing ET with a normal tobacco). In case more than 20 % of ET should be added, the drum has to be inclined.

A. Badstuber

REFERENCE

(1) "Régularité de mélange et de giclage du tambour de laboratoire" from A. Badstuber to U. Nyffeler, dated February 22nd 1980

00001437 01

Source: https://www.industrydocuments.ucsf.edu/docs/yxnl0000

PME PRODUCT DEVELOPMENT, February 1980

PROJECT TITLE	:	NEW PRODUCT DEVELOPMENT LABORATORY
PROJECT LEADER	:	S. BEGUIN
PERIOD COVERED	:	January 24th - February 21st 1980
WRITTEN BY	:	S. BEGUIN

---

1) CIGARETTES PRODUCED IN THE MANUFACTURING DEPARTMENT

a) Total quantity : 304,000
b) Number of prototypes : 65

2) TOBACCO BLEND TRIALS IN THE PRIMARY DEPARTMENT

a) 11 x 1,000 kg (unflavoured)

3) FILTER RODS PRODUCED IN THE FILTER MAKING DEPARTMENT

a) Total quantity : 240,000
b) Number of prototypes : 11

4) PACKS (20 cig.) PRODUCED IN THE PACKING DEPARTMENT

a) Total quantity : 400
b) Number of projects : 1

5) PRODUCT TEST(S) PREPARED : 2

S. Béguin

SEB / cap

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Source: https://www.industrydocuments.ucsf.edu/docs/yxnl0000

PROJECT TITLE : TOBACCO ANALYSIS
PERIOD COVERED : February 1st - February 28th 1980
WRITTEN BY : L. JOSEPH

TOBACCO LOT ANALYSIS

1. Special trials

1.1. Low nitrate samples (cultivation trial of Burley) (1)

The NO_3-N, TA, RS and NH_3-N analyses of the 140 samples are under way.

1.2. Pakistani tobacco (2)

The analyses of the 33 samples are under way.

1.3. Partially contaminated lot (No 9084) (3)

The cigarettes are available, but the smoke analyses have not yet been done.

2. Routine tobacco analyses

Introduction of inputs on EDP

Only four lots of stems.
No smoke analysis was made this month.

Lots under evaluation

About forty lots.

Lots available, but not yet analysed

Sixteen lots.

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ASSISTANCE TO OTHER PROJECTS

1. Spotless

Services were given to Mr. Moser for this project. We have received five samples of raw blend tobacco (4).

2. RCB Monique

Trial Nino No 4

Special cigarettes were made with rod tobacco, the filter was adjusted with tape.
The analyses are under way.

Trial Nino No 5

We have not yet received the smoke analyses.

MISCELLEANEOUS

TLA was made on a sample obtained by mixing five different lots of reconstituted tobacco. The analysis result corresponds to the weighted average obtained with the individual TLA results (table annexed).

L. Joseph

REFERENCES

(1) Monthly report of April 1979
(2) Letter from Mr. C. Jeanneret to Miss L. Joseph, dated February 1, 1980
(3) Letter from Mr. E. Lecoultre to Miss L. Joseph, dated December 17, 1979
(4) Monthly report Spotless, January 1980

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Table 1

RECONSTITUTED BLEND TOBACCOS

1. FILLER ANALYSES

		Lot 0108	Lot 0106	Lot 7067	Lot 7007	Lot 9185	Calcu-lated blend	Analysed blend
TA	%	0.47	0.47	0.43	0.44	0.91	0.54	0.57
RS	%	2.1	1.7	6.4	5.7	3.6	3.9	4.0
NO_3-N	%	0.19	0.17	0.15	0.16	0.46	0.23	0.22
NH_3-N	%	1.80	1.94	0.72	0.12	0.11	0.94	0.86
Chloride	%	0.69	0.76	1.02	1.06	1.42	0.99	1.02
Ashes	%	23.6	24.9	22.6	20.3	17.9	21.9	20.9
K^+	%	5.28	4.76	4.49	4.42	5.84	4.96	5.22
Ca^{2+}	%	2.18	2.39	5.01	4.44	2.13	3.23	3.24
Mg^{2+}	%	0.45	0.42	0.50	0.47	0.60	0.49	0.49
Eq. moist.	%	14.5	13.2	10.3	10.1	13.7	12.2	12.8
F. P. at eq. moist.	ml/10 g	21.8	24.4	31.4	32.3	30.2	28.0	29.2

2. SMOKE ANALYSES

2.1 Cigarette

Tobacco weight	mg	1263	1135	1058	1017	1166	1128	1156
Moisture	%	15.1	15.6	11.6	11.7	14.9	13.8	13.5
RTD	mm H_2O	104	100	123	135	160	124	134
Compressibility	mm	4.73	4.90	3.18	3.93	2.71	3.89	3.40

2.2 Filter

Smoke nicotine	mg/g	0.63	0.75	0.36	0.31	0.60	0.53	0.54
HCN	g/g	172	161	17	16	23	78	47
Aldehydes	mg/g	0.62	0.51	0.67	0.55	0.37	0.54	0.54

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		Lot 0108	Lot 0106	Lot 7067	Lot 7007	Lot 9185	Calcu-lated blend	Analysed blend
2.3 Smoke								
CO	mg/g	20.2	17.7*	18.8	23.6	22.4	20.5	21.5
NO	mg/g	0.42	0.42*	0.15	0.19	0.53	0.34	0.33
DPM	mg/g	19.8	20.1	10.5	10.6	11.0	14.4	14.0
SN	mg/g	0.68	0.79	0.39	0.42	0.75	0.61	0.64
Puff number	nbr/g	13.5	19.1	9.2	9.3	9.8	12.2	10.3
HCN	g/g	560	816	130	145	216	374	303
Aldehydes	mg/g	0.93	0.91	1.55	1.70	1.45	1.31	1.48

* These results were not obtained from this lot (bad combustion), but are an average of results obtained on similar lots.

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Source: https://www.industrydocuments.ucsf.edu/docs/yxnl0000

PROJECT TITLE : Cigarette and Smoke Analysis

Period Covered : January 31 - February 29, 1980
Report Written by : F. Senehi
Report Approved by : F. Lopes

APPOINTMENT

On February 1, 1980, Mr. M. Pittet has been appointed head of the smoke laboratory.

ANALYTICAL SMOKING

- Analyses of cigarettes from Middle East and Africa

A new sampling plan has been defined for the following countries (ref. 1) :

Bahrain
Saudi Arabia
Egypt
Lebanon
Morocco

A total of 31 brands will be analysed and introduced in the next cigarette information report.

- Product reports

The following product reports on new or modified brands have been written :

Brand		Manufacturer	Country of sale
Astor Mild Box	84/F	Reemtsma	West Germany
Astor Mild Princess Pack	94/F	Reemtsma	West Germany
FIB	85/F	Burrus	Switzerland

QC FINISHED PRODUCTS

F. Senehi

Ref. 1 : Letter dd. 02-13-80 from F. Senehi to Mr. S. Pedgrift

0001432707

Source: https://www.industrydocuments.ucsf.edu/docs/yxnl0000

PROJECT TITLE : Additives and Analytical Services

Period Covered : January 31 - February 25, 1980
Report Written by : A. Widmer
Report Approved by : F. Lopes

TRIALS WITH NEW SUPPLIERS OF TOBACCO ADDITIVES

- Inverted sugar (LAUMANN & CO., Bischofszell / yellow sheet 5489, 200 kg) - Ref. 1 :

  Laboratory : The sample is within specifications.
  Panel B : Not accepted because of a lack of cleanness.
  Concluded on February 11, 1980.

- MFSBC dry flavour (PMI, New York / yellow sheet 5596, 540 kg) :

  This product is supplied in the shape of pellets instead of powder. It should avoid the formation of dust during the production of Burley Casing. In order to evaluate the influence on the taste, a sample batch of MLF (1000 kg) was ordered on February 12, 1980.

TRIALS WITH PRE-CUTTING SOLUTIONS

- 80 % artificial honey :

  Artificial honey is Fr. -.58/kg cheaper than natural honey (February 11, 1980). In order to determine the influence of an increased quantity of artificial honey on the taste, a sample batch of MLF (1000 kg) was ordered on February 19, 1980.

TRIALS WITH NEW SUPPLIERS OF GLUE

- Glue for packing machine (LAESSER AG, Erlinsbach, "LESSO 1476" / yellow sheet 5533, 1 kg) :

  Good results have been reached on GD X I. However, the results obtained on HLP are not satisfactory. Another quantity of 50 kg was ordered on February 18, 1980.

TOBACCO

- Determination of sand in Virginia scraps - Ref. 2 :

  Forty-eight sand determinations in two lots of Virginia scraps were effected by "LTR" in Le Mans. The results were considered too high. In order to check the results, we analysed five selected numbers according to our method No 207, and found significantly different results.

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Source: https://www.industrydocuments.ucsf.edu/docs/yxnl0000

In order to solve the problem, we compared, in a first step, different gravimetric methods :

1. PME 207 : Hot treatment with a mixture of perchloric and nitric acid
2. PM A-18 : Ashing, followed by a hot treatment with diluted hydrochloric acid
3. Le Mans : Ashing, followed by a treatment with cold diluted hydrochloric acid

The three methods did not show any significant difference, although the method "Le Mans" showed a tendency to give lower values. It may be due to the fact that SiO_2 is being transformed quantitatively into its insoluble state only if treated hot.

In a second step, we have analysed samples prepared by LTR, and vice versa. The results indicated below are the averages of two determinations.

	Samples LTR		Samples FTR	
No.	FTR Method:PM A-18 (% sand d.w.)	LTR Method:LeMans (% sand d.w.)	FTR Method:PM A-18 (% sand d.w.)	LTR Method:Le Mans (% sand d.w.)
1433/1101	10.4	8.5	4.5	4.1
1433/2311	36.6	34.6	21.0	20.4
1433/2268	19.8	20.8	10.8	9.1
1434/3635	31.5	36.4	14.5	12.9
1434/2848	7.1	6.9	5.8	5.9
1434/3379	27.8	30.1	18.2	16.7

The results show that there is no significant difference from the analytical point of view. Therefore, FTR and LTR samples, even if bearing the same lot numbers, did not have the same content. We suggest that the discrepancy be due to inadequate sampling.

PRODUCT QUALITY

- BRD cigarettes with spots on the filter - Ref. 3 :

According to the production people, the spots had been caused by sludge and rust coming from the compressed air pipe. Compressed air is usually used to clean the pipe when there are no cigarettes in the drum. This hypothesis could be confirmed through the chemical identification of iron in the filter spots.

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Source: https://www.industrydocuments.ucsf.edu/docs/yxnl0000

PROJECT TITLE : Additives and Analytical Services

SERVICES FOR OTHER GROUPS

- Analyses for foil mentholating :

  Menthol in cigarettes (62)

- Analyses for Mr.A. Badstuber :

  Diethylene glycol in tobacco (60)

- Analyses for Mr.D. Schulthess :

  Total nitrogen in extracts (5)

A. Widmer

REFERENCES

1. Monthly report A. Widmer, November 1979

2. Letter from Mr. D. Papin to A. Widmer, dd. February 15, 1980
   Letter from A. Widmer to Mr. D. Papin, dd. February 15, 1980

3. Letter from A. Widmer to Mr. R. Schorpp, dd. February 13, 1980
   Report A. Schwarb, dd. February 13, 1980

0001437710

Source: https://www.industrydocuments.ucsf.edu/docs/yxnl0000

PROJECT TITLE : Material Development

PERIOD COVERED : February 1st - February 29th

WRITTEN BY : P. Balliger

APPROVED BY : F. Lopes

CIGARETTE PAPER

- Mauduit Verge 1100A

  Analyses were carried out with this paper to see if the quality corresponds to Schoeller & Hoesch's Pela 200M for the production of MLK-DB.

  The cigarettes manufactured by PMG-Berlin with this paper were submitted to smoking panel A for taste evaluation. The taste was not as soft and clean as the standard; so, unless this paper is improved, it will not be accepted.

- Verge E 30023 Wattens
  Verge NSP 200 Variant 1 to 6 Glatz

  In order to have different suppliers for MLK-DB cigarette paper, Wattens and Glatz were requested to produce the above-mentioned qualities which should correspond to Schoeller & Hoesch's Pela 200M. Analyses on these papers are presently being made at FTR. According to the results obtained, we will inform Berlin of the qualities to be considered for trials.

POROUS PLUG WRAP

- HF 40 K 28 Variant 4/2 Glatz

  According to analytical results, this filter paper corresponds to Schoeller & Hoesch's FU POV 40L standard quality presently used on full-diluted MLF and also on several other diluted brands. Consequently, MLF-CH will be produced at FTR with this material in order to determine dilution level and smoke deliveries obtained on finished products.

P. Balliger

March 3, 1980
PBA/noh

0001437711

Source: https://www.industrydocuments.ucsf.edu/docs/yxnl0000

PROJECT TITLE : SPECIFICATIONS AND PROCESS ASSURANCE

Period Covered : 25.1.1980 - 29.2.1980
Report Written By : C. Flury + T. Bel
Report Approved By: J.B. Boder

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1. Specifications Fabriques de Tabac Réunies SA

- The processing specifications for blends 53MEM Merit Menthol and 57MFM Marlboro Menthol are cancelled, due to the foil mentholation process. The mother blends Merit resp. Marlboro are used for these two cigarettes.

- The processing specs for BSC Bond Menthol, CRM Checker Menthol, and NPF North Pole, have been modified (after-cutting solution without menthol), due to foil mentholation.

2. Specifications Intertaba S.p.A.

- The diameter of the standard size 7,90 mm filters has been reduced to 7,88 mm, upon request PME.

- All filter RTDs have been brought up to standard (except MAE-120 34.7305 which will follow).

- Upon request of Mr Grünbaum, the plasticizer application to charcoal filters has been reduced from 8,5 to 8,0 %. The reduction to the standard 5% cannot be achieved due to unsufficient hardening of INM's long semi-manufactured rods.

- The filter making specs for non-porous Marlboro filters 100, 102, and 108 mm have been withdrawn.

- Plug wrap BOP 0975 continues to be used on the porous filter DIS-120 (Italian Diana Specially Mild) only. Paper FU-POV (Schoeller & Hoesch) is used on all the other porous filters.

3. Specifications Ph. Morris Holland

- The width of cut for the stems processed in Eindhoven has been adapted to practice from 0,14 to 0,20 mm (old cutters).

- The after-cutting solution has been increased from 36,8 to 39,7 liters, on ARM Armada Menthol. At the same time, cigarette paper 110-6 EP (instead of 110-6) is used, as well as the porous Marlboro 100 mm filter. The objective was to reduce the numbers which were unexpectedly high.

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- The filter making spec for the non-porous Marlboro 100s filter has been withdrawn. After exhaustion of the present stock of this filter, PMH will use the porous 100 mm filter on all their brands.

- PMH now manufacture porous white filters only. New specs were prepared for the semi-diluted 108 and 120 mm Marlboro filters (paper FU-POV 24 L = 7% dilution). On certain minor brands, the porous filter is used on non-diluted cigarettes, together with a non-porous tipping.

- The production of the Ambassador cigarettes has been transferred from Eindhoven to Bergen op Zoom. Eindhoven's AccuRay inspection units of the King Size machines have also been transferred.

- Since beginning December, 1979, the rod length of all King Size cigarettes has been reduced from 64,4 to 64,0 mm. Total cigarette 64 + 20 = 84 mm.

4. Specifications Ph. Morris Germany

- The cigarette making specs MLF 10 Marlboro Filter, and MLK 10 Marlboro King Size, for sale in Italy, have been modified and foresee a 7 % semi-dilution.

- A complete new specification set was prepared for the following projects:

a TAMBAY	PMS Philip Morris Super Lights, for sale in France (see memo Buchmann-Flury 5.2.80)
b VICKY	PLL Parliament, for sale in Germany (see memo Buchmann/Flury 5.2.1980)
c PETER PAN	LAG Lark Filter King and LMB L & M Filter, two L & M brands, for sale in Italy (see memo Buchmann/Flury 28.1.1980).

5. Specifications Ph. Morris Great Britain

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6. Specifications WELTAB SA Bruxelles

- Following FTR, PMH, and PMG, WELTAB has also started with aluminium perforation on the hinge-lid packers. At present, part of the MLF Marlboro Filter production is carried out with this system. Three more groups will be equipped by the end of April, 1980.

- New complete specifications were prepared for project BELTOISE, MAC Muratti Ambassador Extra Mild, 85 mm, for sale in France and Corsica. See memo Fauville/ Flury 11.2.1980.

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7 Specifications Licensees

- The specs for MEK Mercedes King Size, manufactured in Florence, Italy, have been modified to allow the use of 3,75 % Esther (first step).

- All Finnish cigarette making specifications were modified for two reasons:
  = Use of cigarette paper TERCIG H 10 DIN 60, replacing H 7 Vergé M paper. This paper was approved by Panel A.
  = Correction of the cigarette rod length from 60 to 59,4 mm (with 20 mm filter as previously). This modification took actually place in 1974. QC PME became aware of it now, in the context of historical data research (see below).

8. PME Material Specifications

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9. PME Standard Recipes

- PMG's and PMH's local ingredients lists have been ckecked and will be updated.

10. Specifications on EDP

- A project brief has been drafted for preliminary discussions.

11. Process Assurance Fabriques de Tabac Réunies SA

- A study is pending following the FLL Flint Ultra production of the week of 18th February.

12. Process Assurance Intertaba S.p.A.

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13. Process Assurance Ph. Morris Holland

- A first visit was paid to this company, in the week of 18.2.1980. See "February 1980 Report on Visit to PMH".

14. Process Assurance Ph. Morris Germany

- G. Voelkl and A. Buchmann have visited Neuchâtel. Different subjects were discussed. See "February 1980 Report on Visit of PMG".

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15. Process Assurance Ph. Morris Great Britain
16. " " WELTAB SA Bruxelles

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17. Process Assurance Licensees

- Historical data research back to 1973 was made for the Finnish MLF Marlboro Filter production (context: basic blend purchasing price).

C. Flury / T. Bel

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PROJECT TITLE : Physical Testing Methods

Period Covered : February 1 - February 29, 1980
Report Written by : T. Piko
Report Approved by : F. Lopes

Automation of the smoke laboratory

The study regarding the automation of the smoke laboratory has started with the cooperation of "RCB electronic".

Physical tests

In the framework of the physical tests presently being run, three different types of filters have been produced. They will be distributed to the participants in April 1980.

The purpose of this test is to compare the measurements of the RTD (encapsulated) as well as the diameter of porous and non porous filters.

Cigarette compressibility

The new electronic control device will be finished at the beginning of March 1980. A second series of instruments will be ordered after checking of this new device.

Miscellaneous

The instrument "COMPU-TRAC", model MA-6, of MOTOROLA PROCESS CONTROL INC. has been evaluated. This instrument is used to measure moisture according to the thermo-gravimetric principle.

It has not given satisfaction for the following reasons :

- Measuring time too long : 10 - 20 minutes until display of the results, according to the moisture and the kind of tobacco

- Price too high : Sw.Fr. 11'000.-

QC - METHODS

T. Piko

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PROJECT TITLE	: PATENTS
PERIOD COVERED	: February 1980
WRITTEN BY	: J.C. Mandiratta

PHILIP MORRIS EUROPE PATENT COMMITTEE

The PME Patent Committee was held on February 13, 1980 in Neuchâtel.

EVALUATION OF TAMAG/POLYSTREP PATENTS

Some of the untermentioned patents and patent applications of Tamag/Polystrep assets are maintained or abandoned upon recommendation of the PME Patent Committee.

Method and Apparatus for Producing Fibrous Material

This patent is maintained in Great Britain and West Germany. Due to lack of technical interest the West German divisional application P2366086.6 is abandoned.

Smokeable Product with Meerschaum Particles

This patent is abandoned in Luxemburg and maintained in Australia, France, Switzerland and South Africa.

Smokeable Product with Meerschaum Particles

This patent is maintained in West Germany, Great Britain and Austria.

Smokeable Product with Meerschaum Particles as absorbent

This patent is abandoned in Luxemburg and maintained in West Germany, Great Britain and the Soviet Union.

Process of Production of Synthetic Tobacco

This case is abandoned in Luxemburg, Bulgaria and Australia and maintained in West Germany and Great Britain.

NEW PATENT

West German Offenlegungsschrift 2916372.
Title: Box for Smoking articles in the form of cigarettes or the like.

Brown & Williamson West German OS2922283 and 2922284

Upon recommendation of US and PME Patent Committees it is decided to oppose the above mentioned patents in West Germany. Instructions to this effect are given to Dr. Hach.

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NINO - NEW PATENT APPLICATION

The revised application has been sent to Dr. Hach on February 12, 1980 for priority filing in Luxemburg.

NINO - CANDIDA APPLICATION IN THE UNITED STATES

The draft of this application has been received from the Patent Office in Richmond and is presently being revised by the inventors.

PATENT DOCUMENTATION

Todate 3200 patents are on the STAIRS system for patent documentation.

J.C. Mandiratta

26.2.1980 MJA/chs

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T. S. OSDENE

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